

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED DS	DRAWING NO. D407-667-245	REV. C SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (407 HIGH AFT)	SCALE NTS
A	02.05.13	NEW ISSUE	
B	03.05.21	ADD CHAFING SHIELD	
C	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

Qty	Part Number	Description
X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
1	D6011-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
1	D2856-600-851	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
1	D2894-1	SUPPORT
2	D3190-1	CHAFING SHIELD
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-22	CLAMP
2	MS21920-24	CLAMP

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6011-115
FINISHED LENGTH = 112.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 / D2856-600-851 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2894-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT (OPTIONAL).
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.
- 13) INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE OPPOSITE D2894-1 SUPPORT.

UNDER REVIEW

06.06.23 CB

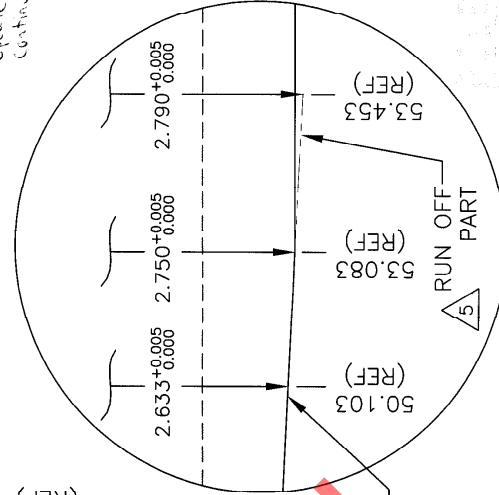
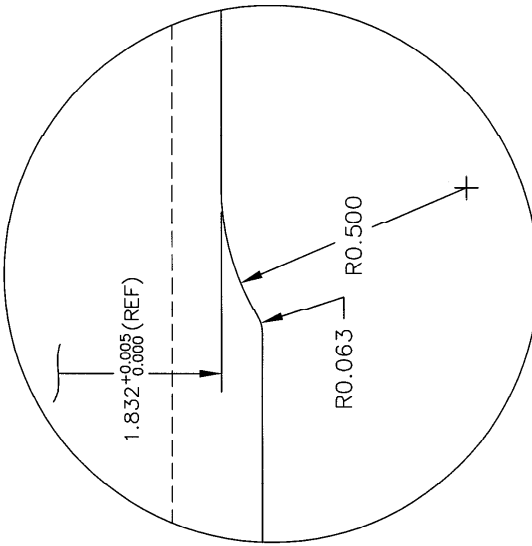
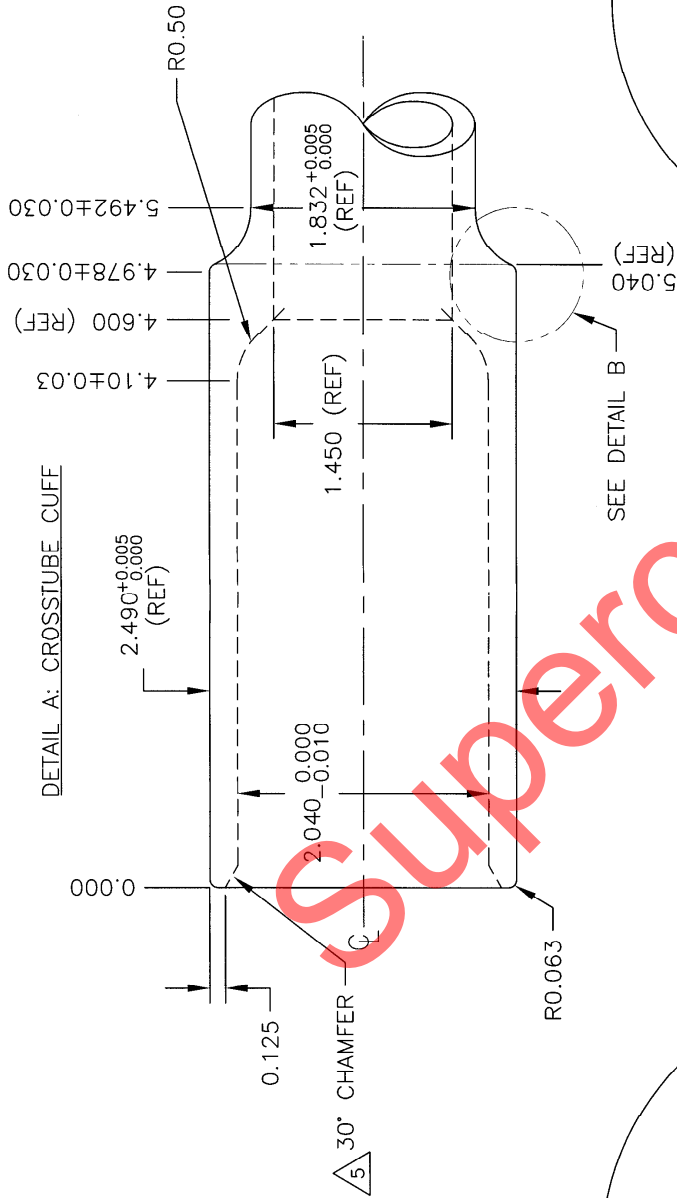
update dwg
continue mfg**UNDER REVIEW**

06.07.10 PA

re-draw detail B

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UNDER REVIEW
06.06.10 PH
re-draw detail B

UNDER REVIEW
06.06.10 CB
update drawings
Continueing

05.07.26

DESIGN		DRAWN BY		DART AEROSPACE LTD.	
CHECKED	PH	PH	PH	DART	WINDSOR, ONTARIO, CANADA
APPROVED	PH	PH	PH	DART	
DATE	05.07.26	DATE	05.07.26	DART	
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		D407-667-245		SHEET 3 OF 3	
		TITLE		SCALE	
		CROSSTUBE ASSY (407 HIGH AFT)		1:1	